

Work Order ID 65550

January 19, 2011 1:39:09 PM



Page 1

Item ID: D3065-7

Accept



Setup Start



Revision ID:

Item Name: Step Spacer

Stop



Start Date: 1/20/11 Start Qty: 40.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-01-19

Tooling:

Date:

Run Start



QC: Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3065	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3065 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-

Deburr if necessary

2024 . 040

B11-1-25

(40)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-1-25

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sub 1/26

contd

(x40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

0.00

Small Fab

Memo

0.00

N/A

Small Fab

Deburr if necessary.

140



NC BRAKE

0.00

Brake NC

Memo

0.00

Ss 11/02/01

Brake NC

Bend as per Dwg D3065

(40)

150



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Ss 11/02/01

Quality Control

(40)

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

Hand

11/02/04

40 0

170 QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

No RP 11-02-4

180 Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

*Small
Fab*

11/02/04

sl (400)

W/O:		WORK ORDER CHANGES					
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Item Name: Step Spacer

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Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

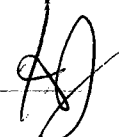


QC

Memo

0.00

Quality Control

11/02/07 
CL 11/02/04

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Picklist Print

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Page 1

Work Order ID: 65550



Parent Item: D3065-7



Parent Item Name: Step Spacer

Start Date: 1/20/11

Required Date: 1/28/11

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: ☐ C ☐ 02.11.01 ☐ Incorporated D3066-1 IPP ☐ KJ/RF
IPP Rev:D Now on Water Jet 06-04-11 JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	216.4595	0.1574	6.627368			

2024-T3 .040 sheet

1811-1-25

Location

Loc Qty

Loc Code

MAT

28.2

114415

28.2

114415

40

MAT22

188.2595

110305

21.93

111786

9.66

112291

28.25

112331

52

113162

76.4195

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FLAT PATTERN

RELEASED

66 06 20 *[Signature]*

0.62

BEND DETAIL

D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) PART IS SYMMETRIC ABOUT CENTERLINE
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

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